

Work Order ID 53053

October 22, 2009 11:29:20 AM



Page 1

Item ID: D3901-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bar

Start Date: 21/10/2009 Start Qty: 6.00



Cost Item ID:

Required Date: 30/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 05-10-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3901

B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

LOW WATER JET

1-Cut as per Dwg D3901

Dwg Rev:

Prog Rev:

2-Deburr if necessary

0.00

05-10-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

05-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3901-3 ^{D119-646} PAR #: N/A Fault Category: Prod. Eng. Coord. NCR: (Yes) No DQA: 1 Date: 09-11-06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 09-11-18

NCR: 53053		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/27	#100	Qty x2 Parts Found to be too long by 1/2". Also dim 62.12 measures 62.625" (1/2" too long also). Program was wrong. It was		Scrap and Destroy Qty x2 And replace B# 111727	 9/10/27	 9/10/27		 9/10/27
		still in Prelem: not approved R.C. LOA.		Fix program and take out of Prelem/make approved Re FAI.	 09/10/26	 09/10/27		 09/10/27

NOTE: Date & initial all entries

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Page 2

Item ID: D3901-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bar

Start Date: 21/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

22 October

150

Identify as per dwg & Stock Location: *W/A*

0.00



Packaging

Memo

0.00

Packaging

PL 2-11-5 106

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/06
MF
09-11-05

Picklist Print

Page 1

October 22, 2009 11:29:28 AM

Work Order ID: 53053



Parent Item: D3901-3RevB



Parent Item Name: Bar

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.500X012.000		Purchased	No			100	sf	22.9728	0.7768			
304 BAR .500 X 12.00												

139-10-26

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	22.9728	
111722	10.9728	
112778	12	

111722

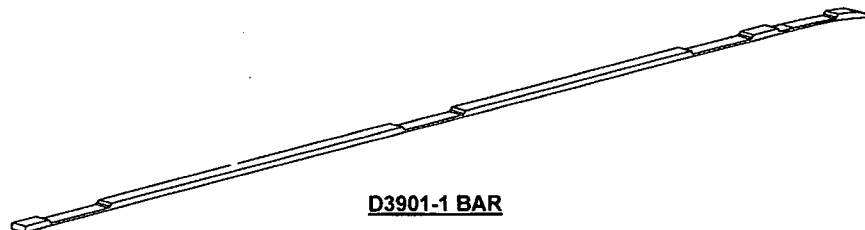
6

304 .50

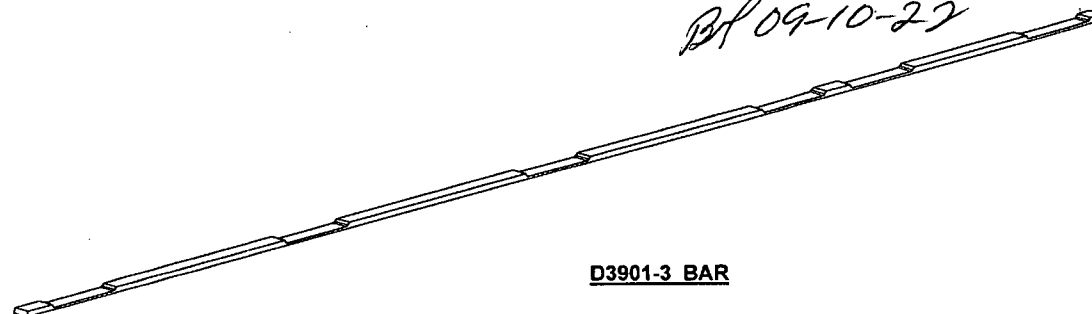
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 53053

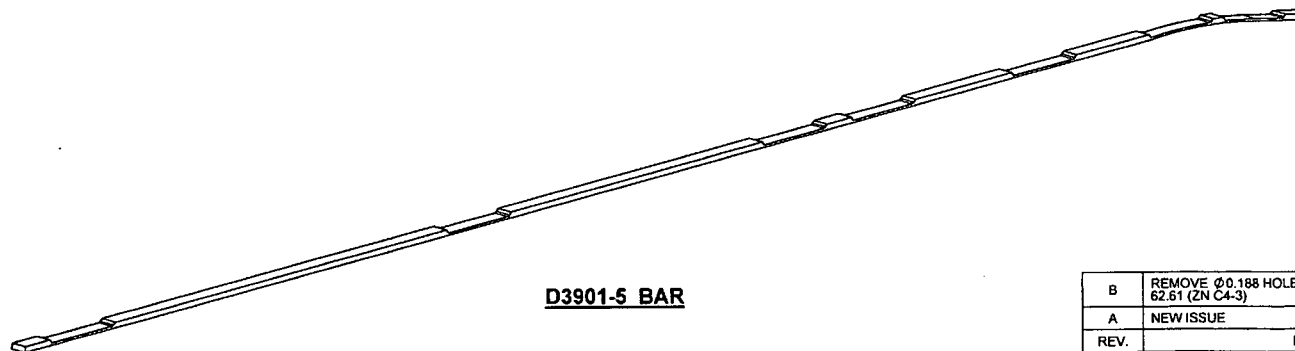
BA 09-10-22



D3901-1 BAR



D3901-3 BAR



D3901-5 BAR

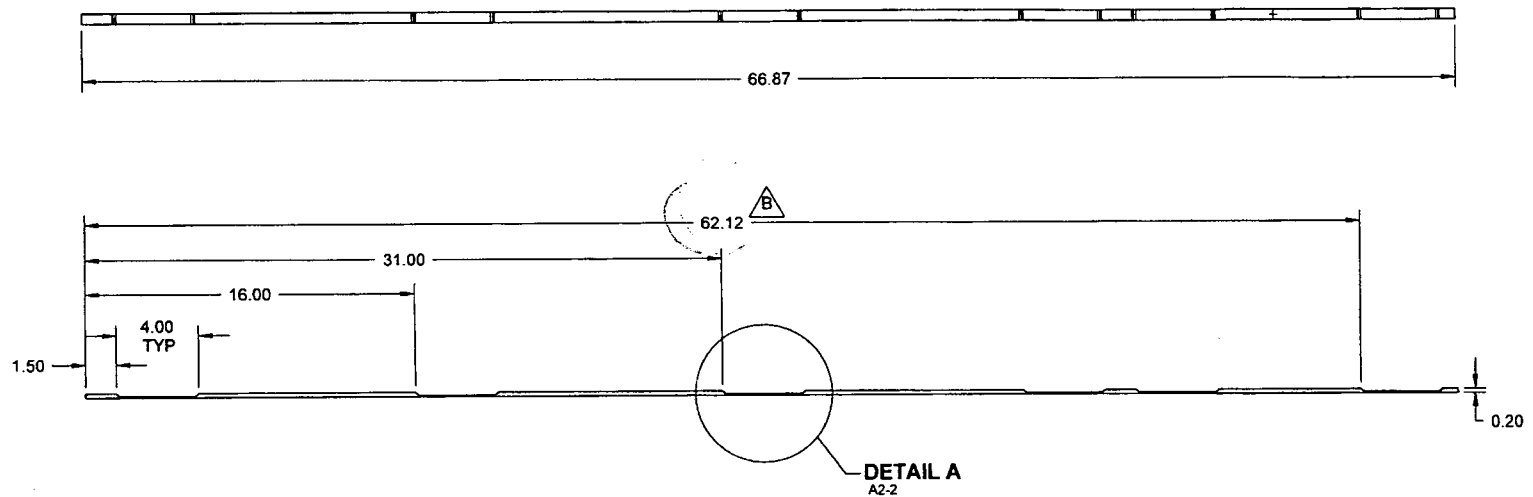
RELEASED
 09/07/13 M

B	REMOVE Ø0.188 HOLES FROM D3901-1/-3/-5; 62.12 WAS 62.61 (2N C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>AB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D3901	SHEET 1 OF 4
APPROVED	<i>up</i>	TITLE	SCALE
DE APPR.	<i>J</i>	BAR	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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53053

8 7 6 5 4 3 2 1



0.50
REF

D3901-3 BAR

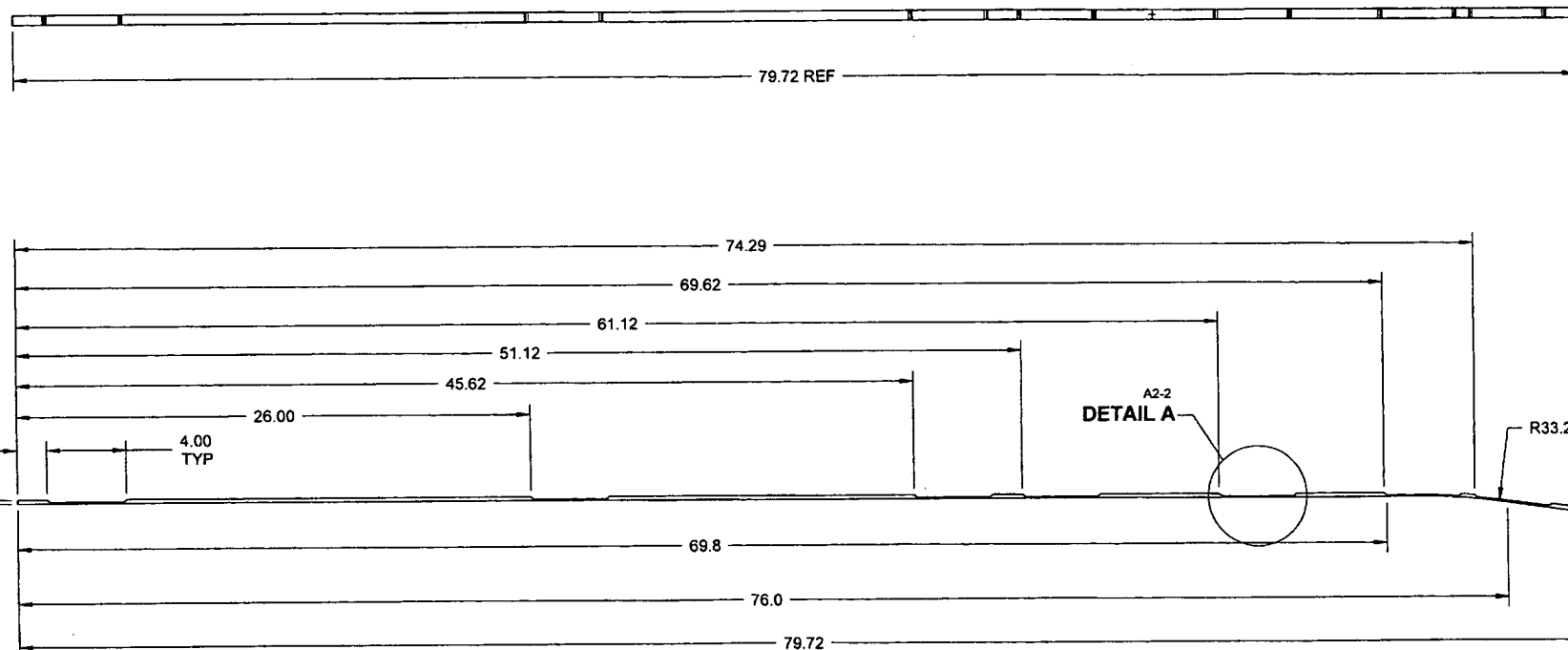
RELEASED
09/07/15 MB

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3901-3 = 1.53 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3901	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
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8 7 6 5 4 3 2 1

53053



D3901-5 BAR

RELEASED
12/15/11

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3901-5 = 1.82 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3901	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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